

Work Order ID 92357

92357

Page 1

October-30-12 9:13:23 AM

Item ID: D3859-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate

Start Date: 10/24/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/09/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: HLJ

Date: 12-10-30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3859

REV A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3859 Dwg Rev: A Prog Rev: A 2-

Debur if necessary

304.063

(B)

B12-14-3

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(6)

B12-11-3

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
15

6

12-11-05

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Accept

N900040100

Setup Start

NS1

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Large Fab	0.00							
130									
Large Fab	Memo	0.00							
Large Fab	1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod Batch: <u>M122257</u> 2-Weld hard facing as per Dwg D3859 A/R 2059B Hard Coat rod Batch: <u>M123667</u> *****use DT9462 for welding*****								
140	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

6 12-11-16

6 12-11-19

D4
09
09

6 12-11-19

D4
09
09

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Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 10/24/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/09/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Memo START TIME: 12:00 OVEN TEMPERATURE: FINISH TIME: 12:30									
170 *170* QC Quality Control	QC3- Inspect Part Finish	0.00							
Memo									
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST500</u>	0.00							
Memo									

6X  12/11/21

6  12-11-21

4 12/11/21 JB

m122a66

3200F

12-30

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Page 4

Item ID: D3859-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate
 Start Date: 10/24/12 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/09/12 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/11/22 *[Signature]*
mf
 12-11-21

Picklist Print

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Page 1

Work Order ID: 92357

Parent Item: D3859-041

Start Date: 10/24/12

Required Date: 11/09/12

Parent Item Name: Wearplate

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	398.6780	0.85	3.4	5	11-2-11-3	

Location	Loc Qty	Loc Code
MAT020	398.678	
122245	51.078	
122753	53.9	
123136	293.7	

D3009-3
Cup

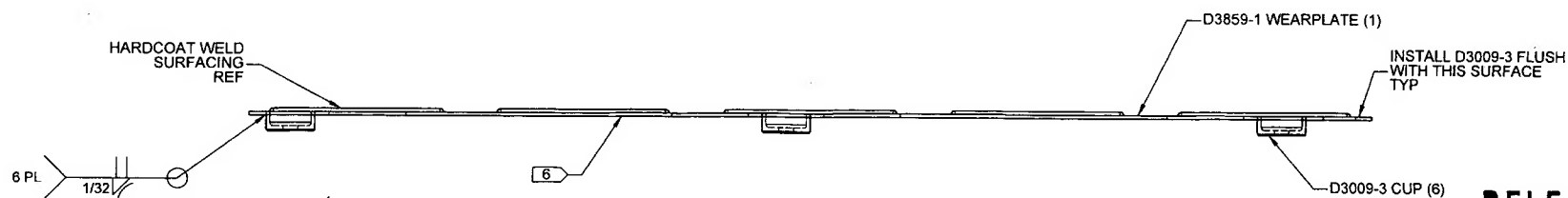
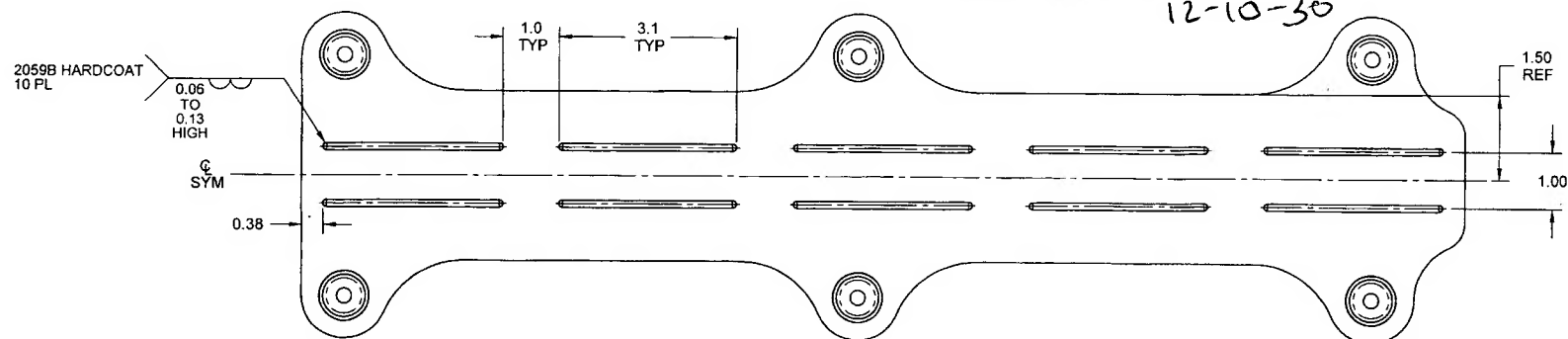
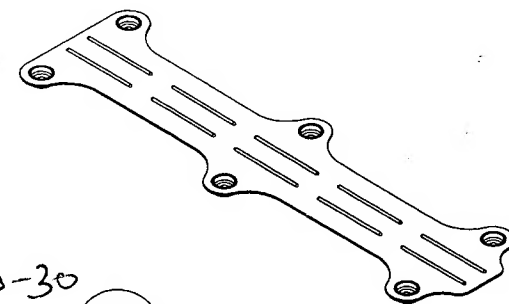
Manufactured No 130 Each 34.0000

6 24 12-11-16

Location	Loc Qty	Loc Code
WA	34	
79078	30	
88386	4	
86809	424	

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

SHOP COPY
RETURN
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 92357 MCL
12-10-30



D3859-041 WEARPLATE

RELEASED
09 01.26

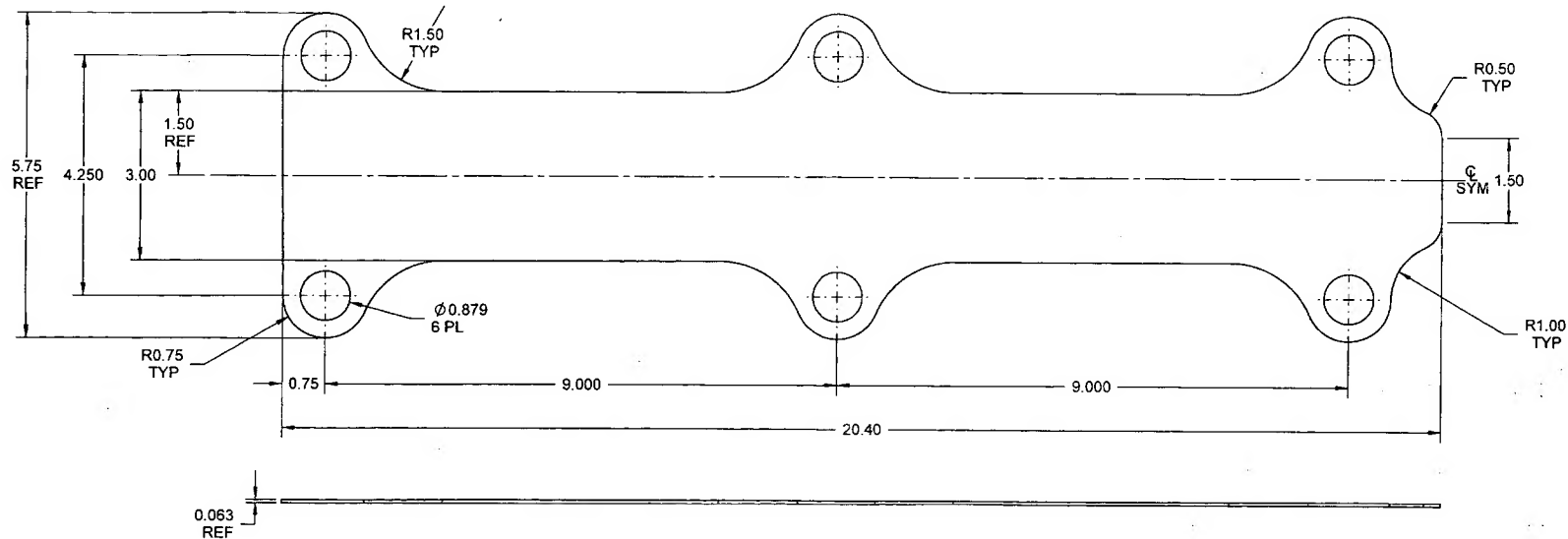
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.46 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE		09.01.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.26		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3859**
TITLE **WEARPLATE**
REV. A
SHEET 1 OF 2
SCALE
NTS
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92357



D3859-1 WEARPLATE

RELEASED
11 09.01.26

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK), PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.29 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3859	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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